

How to Create a Control Plan for Electronic Product Assembly

A control plan is the reference document that ties every manufacturing step to its inspection method, sampling rule, and reaction plan. This guide walks through how to create a control plan for an electronic product assembly line, following the manufacturing flow from incoming goods inspection through pre-assembly, final assembly, packing, and outgoing inspection. Use it as a reference when building or reviewing a control plan for your own assembly process.

				PROCESS CONTROL PLAN Product [Confidential]								
Revision level: A1		Release Date: Dec. 17, 2019		Status		First version						
零件/过程 Part / Process Number	过程名称/操 作描述Process Name / Work Description	设备、装置、夹 具、刀具Machine / Device / Jig / Tool	编号 No.	特性Characteristics	特殊特性 Classification Special Characteristics	方法Method	评价/测量技术Eval uation / Measurement Technique	样本Sampling	控制方法 Control Method	反应计划 Reaction Plan		
				产品 Product	过程 Process	产品/过程规范/公差Production / Process Specification / Tolerance	数量Quantity	频率 Frequency				
	手工manually		8	包装方式Packaging method	目视 Visual	C	符合包装作业指导书要求 Should meet the requirements of the packaging operation instruction	目视 Visual	GIL AQL0.65/1.0	每批Per lot	OQC检验报表in specification record	返工/报废 Rework / Scrap
	手工manually		9	箱唛 Identification	目视 Visual	C	符合包装作业指导书要求 Should meet the requirements of the packaging operation instruction	目视 Visual	GIL AQL0.65/1.0	每批Per lot	OQC检验报表in specification record	返工/报废 Rework / Scrap
	电子称Electronic balance		10	称重 Weigh	目视 Visual	C	符合包装要求 Should meet the requirements of the packaging	目视 Visual	1 box	每批Per lot	OQC检验报表in specification record	返工/报废 Rework / Scrap

Special Characteristics Definition: 特殊特性定义:

An abbreviation of the classification that has been assigned to the process characteristics. If any. This field is used to identify characteristics that require special manufacturing control (e.g., Critical, Significant, Key Leading, etc.). 已分配给过程特性的分类的缩写 (如果有的话)。此字段用于识别需要特殊制造控制的特性 (如关键、重要、关键领导等)。

For example 例如

A = Critical to Quality and therefore needs to have very specific actions taken
A=对质量至关重要, 因此需要采取非常具体的措施

B = Functional dimensions and therefore tolerances need to be monitored
B=功能尺寸, 因此需要监控公差

C = Specific attributes need monitoring with SPC
C=需要使用SPC监控的特定属性

D = Function inspection required
D=需要进行功能检查

DOCUMENT CONTROL DATA 文件控制数据			
Revision	A1	Description of change	
Author	AlexChen	This change	增加了出货检验及组装打胶的设备参数等Added proess outgoing inspection and equipment parameters for glue equipment ect.
Date Released	Dec. 17, 2019	Included	

Control plan table showing document control data: revision level, author, date, and description of change.

Prerequisites

Before you build the control plan, have the following ready:

- Product specifications for each critical component (battery, PCBA, motor, etc.)
- A list of equipment and tools used at each process step
- Applicable sampling standards (for example, AQL tables)
- Inspection record forms: IQC report, first piece inspection record, inline inspection record, PQC inspection record, and OQC inspection record

Header

The control plan header identifies the plant, customer, program, part number, revision level, plan type, and approval status. The source material for this guide shows only the revision-level fields (revision "A1," authored by AlexChen, dated Dec. 17, 2019, with a description of changes). Plant, customer, program name, part number, plan type, and approval status are not shown and must be filled in with your project's actual details when you create the plan.

Process flow

Start by reviewing the overall structure of the control plan. Each row corresponds to a specific process step and is organized by process step, characteristic, method, sampling, and control/reaction plan. The columns typically include process number, description, equipment/tool, product, process, special characteristics, production specification/tolerance, evaluation/measurement technique, sampling quantity, frequency, control method, and reaction plan.

The assembly flow covered in this example includes the following operations, in sequence:

Operation	Process name	Equipment/tool	Linked PFMEA row
1	Incoming goods inspection	Manual visual check, multimeter, comprehensive tester, calipers	Not specified in source
2	Soldering on PCBA	Soldering iron	Not specified in source
3	Main board EVA sticking	Tweezers	Not specified in source
4	Shell/nut mounting	Hand die cutting machine / bottom mold of shell	Not specified in source
5	Lock PCBA board	Electric screwdriver/fixture	Not specified in source
6	Pre-final assembly sub-assembly check	Manual comparison against reference samples	Not specified in source

7		Semi-finished product inspection	Visual and instrument inspection	Not specified in source
8		Glue application	Glue equipment (air pressure/speed control)	Not specified in source
9		Battery cover assembly	Electric screwdriver	Not specified in source
10		Finished product inspection	Visual and functional check, air gun	Not specified in source
11		Packing	Blister box, color box	Not specified in source
12		Outgoing inspection	Random sampling per checklist	Not specified in source

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							编号 No.	产品 Product		过程 Process	方法Method		评价/测量技术Eva luation / Measurement Technique			样本Sampling	
											数量Quantity	频率 Frequency					
40	组装 Assembly	Fixture				胶水不能过多,过少,胶水要均匀/Not too much or little glue,Glue coating should be even								首检、巡检记录 first piece inspection record + inline inspection record	返工/报废 Rework / Scrap		
		手工 manually	2	按摩刷Massage brush	装按摩刷 Install massage brush	C	检查按摩刷与硅胶套之间不可有间隙 当有胶水溢出时,及时清 洁 make sure there is no gap between the massage brush and the silicone sleeve Clean in time when glue overflows	目视 Visual	5 Pcs	每2小时 Every 2H			首检、巡检记录 first piece inspection record + inline inspection record	返工/报废 Rework / Scrap			
		电批/治具Electri c screwdriver / Fixture	3	负极弹簧Spring 手柄尾盖Cover, 螺钉ScrewK1.5*2.5	锁电池盖螺丝 Assemble battery cover	A	电批扭力: 2.5kgf.cm~3.0kgf.cm 螺丝是否打紧, 螺丝不能锁错位、 锁偏、锁花等Torque: 2.5kgf.cm~ 3.0kgf.cm,make sure the screw is tighten, No sliding wire,or lock not in place,or lock deviation, etc	目视、仪器检测 Visual instrument inspection	5 Pcs	每2小时 Every 2H			首检、巡检记录 first piece inspection record + inline inspection record	返工/报废 Rework / Scrap			
		手工 manually	4	产品/底盖/防水圈 Product /cover / waterproof ring	合盖盖、外观 检查 Closing cover, Appearance check	C	检查按摩刷与硅胶套之间不可有间隙 No gap between the massage brush and the silicone sleeve	目视 Visual	5 Pcs	每2小时 Every 2H			首检、巡检记录 first piece inspection record + inline inspection record	返工/报废 Rework / Scrap			
50	成品检测 Finished product inspection	按键 Key	1	成品 Finished product	按键测试 Key test	D	检查按键手感合格 Check push-button is qualified	目视 Visual	100%	全检Full inspection			PQC检验报告 Inspection record	返工/报废 Rework / Scrap			
		灯光 LED	2	成品 Finished product	目视 Visual	C	检验LED亮度 Check LED brightness	目视 Visual	100%	全检Full inspection			PQC检验报告 Inspection record	返工/报废 Rework / Scrap			
		工作模式Working mode	3	成品 Finished product	目视 Visual	D	符合测试作业指导书要求 Meet the requirements of test operation instruction	目视 Visual	100%	全检Full inspection			PQC检验报告 Inspection record	返工/报废 Rework / Scrap			
		外观 Appearance	4	成品 Finished product	目视 Visual	C	无脏污等外观不良 No dirt or other appearance defects	目视 Visual	100%	全检Full inspection			PQC检验报告 Inspection record	返工/报废 Rework / Scrap			

Control plan table listing process numbers, descriptions, equipment/tools, product and process fields, special characteristics, specifications, measurement techniques, sampling, frequency, control method, and reaction plan.

Before starting final assembly, stop the line and check key sub-assemblies. For example, test the push-button for correct hand feel by comparing it against a known good sample, and, where available, reference samples that are too hard or too soft.

During packing, the flow moves from final inspection into packing steps, covering appearance inspection, blister box/battery placement, cleaning, and folding of the color box.

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				产品 Product	过程 Process		产品/过程规范/公差Production / Process Specification / Tolerance	评价/测量技术Evaluation / Measurement Technique	样本Sampling			
									数量Quantity	频率Frequency		
50	成品检测 Finished product inspection	Fixture		螺钉ScrewK81.5*2.5	battery cover		3.0kgf.cm make sure the screws is tighten. No sliding wire, or lock not in place, or lock deviation, etc	Inspection		Every 2H	record + inline inspection record	Scrap
		手工 manually	4	产品/尾盖/防水圈 Product / cover / waterproof ring	合尾盖, 外观检查 Closing cover, Appearance check	C	检查按摩刷与硅胶套之间不可有间隙 No gap between the massage brush and the silicone sleeve	目视 Visual	5 Pcs	每2小时 Every 2H	首检, 巡检记录表 first piece inspection record + inline inspection record	返工/报废 Rework / Scrap
		按键 KEY	1	成品 Finished product	按键测试 Key test	D	检查按键手感合格 Check push-button is qualified	目视 Visual	100%	全检 Full inspection	PQC检验报表 pection record	返工/报废 Rework / Scrap
		灯光 LED	2	成品 Finished product	目视 Visual	C	检测LED亮度 Check LED brightness	目视 Visual	100%	全检 Full inspection	PQC检验报表 pection record	返工/报废 Rework / Scrap
		工作模式 Working mode	3	成品 Finished product	工作模式测试 Working mode test	D	符合测试作业指导书要求 Meet the requirements of test operation instruction	目视 Visual	100%	全检 Full inspection	PQC检验报表 pection record	返工/报废 Rework / Scrap
		外观 Appearance	4	成品 Finished product	目视 Visual	C	无脏污等外观不良 No dirt or other appearance defects	目视 Visual	100%	全检 Full inspection	PQC检验报表 pection record	返工/报废 Rework / Scrap
		声音 Voice	5	成品 Finished product	噪音测试 Noise test	D	无噪音、异响 No noise or abnormal	听觉 仪器检测Hearing instrument inspection	100%	全检 Full inspection	PQC检验报表 pection record	返工/报废 Rework / Scrap
		防水测试设备 Waterproof test equipment	6	成品 Finished product	防水测试Waterproof test	D	产品放入1m水深30分钟, 拆机无进水 The product is put into 1 m water depth for 30 minutes, and no water should be found when disassembled	目视 Visual	2 pcs	每班 Per shift	防水测试记录 Waterproof test record	返工/报废 Rework / Scrap
		气枪 Air gun	1	成品 Finished product	拆电池, 吹尘 Remove battery/Blow dust	C	检查是否漏拆电池, 不能有脏污。 No omission to remove the battery and no dirt.	目视 Visual	5 Pcs	每2小时 Every 2H	首检, 巡检记录表 first piece inspection record + inline inspection record	返工/报废 Rework / Scrap

Control plan table showing the transition from inspection to packing, including appearance inspection, blister box/battery placement, cleaning, and color box folding.

Product characteristics

The following characteristics are checked at incoming inspection and carried through the control plan. Special characteristics are classified using letters:

- A – Critical to quality, requiring very specific actions
- B – Functional dimension that needs monitoring
- C – Attribute requiring monitoring with Statistical Process Control (SPC)
- D – Function inspection required

Characteristic	Specification/ tolerance	Classification	Measurement method
General appearance	No dirt, shrinkage, or glue shortage	Not specified	Manual visual inspection
Battery voltage	Higher than 1.61V	Not specified	Multimeter (instrument testing)
Battery appearance	Mark intact and undamaged	Not specified	Visual

PCBA parts	No missing or losing electronic parts	Not specified	Visual (100% inspection)
PCBA QC pass sticker	Passed test	Not specified	Visual (100% inspection)
PCBA packaging	Packed in antistatic box	Not specified	Visual (100% inspection)
Motor speed	6500 $\pm$ 10% RPM	Not specified	Instrument testing
Motor current	1.5V working voltage, current < 345mA	Not specified	Instrument testing
Motor voltage	Starting voltage 0.4V, rated voltage 1.5V	Not specified	Instrument testing
Motor service life	At least 500h	Not specified	Instrument testing
Motor noise	< 60dB under rated voltage	Not specified	Instrument testing
Motor size	30 $\times$ 15.2 $\times$ 11.8 mm	Not specified	Calipers
Motor appearance	No oxidation/dirt, mark intact	Not specified	Visual
Battery cover screw	Tightened, no sliding wire, lock not deviated	A/D (special characteristic)	Visual, instrument (torque)

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			产品 Product	过程 Process		产品/过程规范/公差 Production / Process Specification / Tolerance	评价/测量技术Eva luation / Measurement Technique	样本Sampling						
								数量Quantity	频率 Frequency					
10	电池检测 Battery testing	色温仪/灯箱 Colorimeter / light box	3	色差 Chromatic aberration	目视 Visual	C	参照样品及色卡 Reference samples and color cards	目视、仪器检测 Visual/Instrument Inspection	GI, AQL0.6/1.0	每批Per lot	来料检验报告 IQC report	挑选/退货 sort out/Return to supplier		
		万用表Multimeter	1	电池性能Battery performance	功能Function	D	电压高于1.61V Voltage higher than 1.61v	仪器检测Instrument testing	GI, AQL0.6/1.0	每批Per lot	来料检验报告 IQC report	挑选/退货 sort out/Return to supplier		
		手工manually	2	外观 Appearance	目视 Visual	C	标识完好及无破损 Mark intact and undamaged	目视 Visual	GI, AQL0.6/1.0	每批Per lot	来料检验报告 IQC report	挑选/退货 sort out/Return to supplier		
	PCBA检测 PCBA inspection	测试架 Test Fixture	1	全功能测试 Full Function test	功能Function	D	通过测试程序 Pass test procedure	目视、测试架检测 Visual, Test Fixture	100%	全检Full inspection	来料检验报告 IQC report	挑选/退货 sort out/Return to supplier		
		手工manually	2	外观 Appearance	目视 Visual	C	无掉件No missing/losing electronic parts	目视 Visual	100%	全检Full inspection	来料检验报告 IQC report	挑选/退货 sort out/Return to supplier		
		手工manually	3	添加QC通行证标签 Add QC Pass sticker	目视 Visual	D	合格PASSED TEST	目视 Visual	100%	全检Full inspection	来料检验报告 IQC report	挑选/退货 sort out/Return to supplier		
		手工manually	4	装在防静电托盘中 Pack in Antistatic box	目视 Visual	D	合格PASSED TEST	目视 Visual	100%	全检Full inspection	来料检验报告 IQC report	挑选/退货 sort out/Return to supplier		
	马达检测 Motor inspection	电机综合测试仪Motor comprehensive tester	1	转速Speed	功能Function	D	6500+-10% RPM	仪器检测Instrument testing	GI, AQL0.6/1.0	每批Per lot	来料检验报告 IQC report	挑选/退货 sort out/Return to supplier		
			2	电流Electric current	功能Function	D	1.5V额定工作电压下，额定电流小于345mA working under rated voltage(1.5V), rated current is less than 345ma	仪器检测Instrument testing	GI, AQL0.6/1.0	每批Per lot	来料检验报告 IQC report	挑选/退货 sort out/Return to supplier		
			3	电压Voltage	功能Function	D	启动电压Starting voltage0.4V 额定电压Rated voltage1.5V	仪器检测Instrument testing	GI, AQL0.6/1.0	每批Per lot	来料检验报告 IQC report	挑选/退货 sort out/Return to supplier		
		测试架 Test Fixture	4	寿命 Service life	功能Function	D	间接工作至少500H Indirect work at least 500h	仪器检测Instrument testing	SI	每批Per lot	来料检验报告 IQC report	挑选/退货 sort out/Return to supplier		

Control plan table showing incoming goods inspection, battery testing, PCBA inspection, and motor inspection, with columns for characteristics, methods, sampling, and reaction plans.

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									数量Quantity	频率 Frequency			
70	出货检验 Outgoing inspection	外观 Appearance	1	成品 Finished product	目视 Visual	C	无脏污等外观不良 Should be no dirt and other appearance defects	目视 Visual	GI, AQL0.65/1.0	每批Per lot	OQC检验报表 Inspection record	返工/报废 Rework / Scrap	
		按键 Key	2	成品 Finished product	按键测试 Key test	D	检查按键手感合格 Check push-button handfeel, Should be qualified	目视 Visual	GI, AQL0.65/1.0	每批Per lot	OQC检验报表 Inspection record	返工/报废 Rework / Scrap	
		灯光 LED	3	成品 Finished product	目视 Visual	C	检验LED亮度 Check LED brightness	目视 Visual	GI, AQL0.65/1.0	每批Per lot	OQC检验报表 Inspection record	返工/报废 Rework / Scrap	
		工作模式Working mode	4	成品 Finished product	工作模式测试 Working mode test	D	符合测试作业指导书要求 Should Meet the requirements of test operation instruction	目视 Visual	GI, AQL0.65/1.0	每批Per lot	OQC检验报表 Inspection record	返工/报废 Rework / Scrap	
		声音Voice	5	成品 Finished product	噪音测试 Noise test	D	无噪音、异响,≤58db Should be No noise or abnormal, ≤58db	听觉 仪器检测Hearing, Ins trument inspection	GI, AQL0.65/1.0	每批Per lot	OQC检验报表 Inspection record	返工/报废 Rework / Scrap	
		防水测试设备 Waterproof test equipment	6	成品 Finished product	防水测试Wat erproof test	D	产品放入1m水深30分钟,拆机无进水 put into 1 m water depth for 30 minutes, and no water Should be found after disassembled	目视 Visual	2 pcs	每批Per lot	OQC检验报表 Inspection record	返工/报废 Rework / Scrap	
		手工 manually	7	纸箱/产品 Box/Product	跌落测试 Drop Test	D	纸箱从1m高处跌落6个面 产品无破损,功能正常The box fall from a height of 1 m(6 surfaces).The products Should not be damaged, and the function is normal	目视、仪器检测 Visual/instrument inspection	2 pcs	每批Per lot	OQC检验报表 Inspection record	返工/报废 Rework / Scrap	
		手工 manually	8	包装方式Packaging method	目视 Visual	C	符合包装作业指导书要求 Should meet the requirements of the packaging operation instruction	目视 Visual	GI, AQL0.65/1.0	每批Per lot	OQC检验报表 Inspection record	返工/报废 Rework / Scrap	
		手工 manually	9	箱唛 Identification	目视 Visual	C	符合包装作业指导书要求 Should meet the requirements of the packaging operation instruction	目视 Visual	GI, AQL0.65/1.0	每批Per lot	OQC检验报表 Inspection record	返工/报废 Rework / Scrap	
		电子称Electronic	10	称重	目视 Visual	C	符合包装要求 Should meet the requirements of the	目视 Visual	1 pc	每批Per lot	OQC检验报表 Inspection record	返工/报废 Rework / Scrap	

Control plan table defining special characteristics A, B, C, D alongside document control data.

Process characteristics

Process-level parameters are set for each pre-assembly and assembly operation, with defined limits and inspection frequency.

Process parameter	Target setting	Limit	Monitoring frequency	Responsible role
Soldering iron temperature	350°C	± 30°C	5 pieces every 2 hours	Line leader or quality inspector
Welding spot time	2–3 seconds	N/A	5 pieces every 2 hours	Line leader or quality inspector
Main board EVA sticking	No skew, no LED occlusion	N/A	5 pieces every 2 hours	Line leader or quality inspector
Shell/nut mounting	Nut pressed to bottom, no shell damage	N/A	5 pieces every 2 hours	Line leader or quality inspector
PCBA screw torque	2.0–2.5 kgf.cm	No damage to screw or PCBA	5 pieces every 2 hours	Line leader or quality inspector
Glue application (setting 1)	Air pressure 0.15–0.2 MPa	Speed 20–25	5 pieces every 2 hours	Line leader or quality inspector
Glue application (setting 2)	Air pressure 0.18–0.25 MPa	Speed 26–30	5 pieces every 2 hours	Line leader or quality inspector
Glue application (setting 3)	Air pressure 0.22–0.35 MPa	Speed 31–35	5 pieces every 2 hours	Line leader or quality inspector
Battery cover screw torque	2.5–3.0 kgf.cm	No sliding wire, lock deviation	5 pieces every 2 hours	Line leader or quality inspector

- Semi-finished product inspection: 100% full inspection covering key test, LED test, working mode test, appearance, and noise test; results recorded in the PQC inspection record.
- Finished product inspection: 100% inspection by a dedicated inspector, covering key test, LED brightness, working mode, appearance, noise, waterproofing, and removal of battery/dust; results recorded in the PQC inspection record.

- Outgoing inspection: Random sampling, GII, AQL 0.65/1.0, 2 pieces per lot for product checks and 1 box per lot for packaging; results recorded in the OQC inspection record.

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									数量Quantity	频率Frequency							
10	电池检测 Battery testing	色温仪/灯箱 Colorimeter / light box	3	色温 Chromatic aberration	目视 Visual	C	参照样品及色卡 Reference samples and color cards	目视、仪器检测 Visual/Instrument Inspection	GII, AQL0.6/1.0	每批Per lot	来料检验报告 IQC report	挑选/退货 sort out/Return to supplier					
		万用表Multimeter	1	电池性能 Battery performance	功能Function	D	电压高于1.61V Voltage higher than 1.61v	仪器检测Instrument testing	GII, AQL0.6/1.0	每批Per lot	来料检验报告 IQC report	挑选/退货 sort out/Return to supplier					
		手工manually	2	外观 Appearance	目视 Visual	C	标识完好及无破损 Mark intact and undamaged	目视 Visual	GII, AQL0.6/1.0	每批Per lot	来料检验报告 IQC report	挑选/退货 sort out/Return to supplier					
	PCBA检测 PCBA inspection	测试架 Test Fixture	1	全功能测试 Full Function test	功能Function	D	通过测试程序 Pass test procedure	目视、测试架检测 Visual/Test Fixture	100%	全检Full inspection	来料检验报告 IQC report	挑选/退货 sort out/Return to supplier					
		手工manually	2	外观 Appearance	目视 Visual	C	无掉件No missing/losing electronic parts	目视 Visual	100%	全检Full inspection	来料检验报告 IQC report	挑选/退货 sort out/Return to supplier					
		手工manually	3	添加QC通行证标签 Add QC Pass sticker	目视 Visual	D	合格PASSED TEST	目视 Visual	100%	全检Full inspection	来料检验报告 IQC report	挑选/退货 sort out/Return to supplier					
		手工manually	4	装在防静电盒中 Pack in Antistatic box	目视 Visual	D	合格PASSED TEST	目视 Visual	100%	全检Full inspection	来料检验报告 IQC report	挑选/退货 sort out/Return to supplier					
	马达检测 Motor inspection	电机综合测试仪Motor comprehensive tester	1	转速Speed	功能Function	D	6500+/-10% RPM	仪器检测Instrument testing	GII, AQL0.6/1.0	每批Per lot	来料检验报告 IQC report	挑选/退货 sort out/Return to supplier					
			2	电流Electric current	功能Function	D	1.5V额定工作电压下，额定电流小于345mA working under rated voltage(1.5V), rated current is less than 345ma	仪器检测Instrument testing	GII, AQL0.6/1.0	每批Per lot	来料检验报告 IQC report	挑选/退货 sort out/Return to supplier					
			3	电压Voltage	功能Function	D	启动电压Starting voltage0.4V 额定电压Rated voltage1.5V	仪器检测Instrument testing	GII, AQL0.6/1.0	每批Per lot	来料检验报告 IQC report	挑选/退货 sort out/Return to supplier					
		测试架 Test Fixture	4	寿命 Service life	功能Function	D	间接工作至少500H Indirect work at least 500h	仪器检测Instrument testing	SI	每批Per lot	来料检验报告 IQC report	挑选/退货 sort out/Return to supplier					

Control plan table showing soldering iron use, static ring requirements, temperature/time settings, and inspection methods for pre-assembly operations.

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零件/过程 编号 Part / Process Number	过程名称/操 作描述Process Name / Work Description	设备、装置、夹 具、刀具Machin e / Device / Jig / Tool	编号 No.	特性Characteristics		特殊特性 分类Special Characte ristics	方法Method						控制方法 Control Method	反应计划 Reaction Plan	
				产品 Product	过程 Process		产品/过程规范/公差Production / Process Specification / Tolerance	评价/测量技术Eval uation / Measurement Technique	样本Sampling		控制方法 Control Method	反应计划 Reaction Plan			
									数量Quantity	频率Frequency					
30	半成品检测 Semi finished product inspection +	自动打螺丝设备/ 产品固定治具Automatic equipment Fixture	18	螺钉Screw PM2*6	锁马达螺丝 Lock motor cover screw	D	Whether the motor cover is aligned. 电批扭力: 2.5kgf.cm~3.0kgf.cm 螺丝是否打紧, 螺丝不能锁紧, 锁不到位, 锁偏、锁花等Torque: 2.5kgf.cm~ 3.0kgf.cm.The screw is tightened. No sliding wire, or lock not in place, or lock deviation, etc	目视、仪器检测 Visual/Instrument inspection	5 Pcs	每2小时 Every 2H	首检、巡检记录 表 first piece inspection record + inline inspection record	返工/报废 Rework / Scrap			
		按键 Key	1	半成品Semi finished product	按键测试 Key test	D	检查按键手感合格 Check push-button is qualified in handfeel	目视 Visual	100%	全检Full inspection	PQC检验报表 pectionrecord	返工/报废 Rework / Scrap			
		灯光 LED	2	半成品Semi finished product	目视 Visual	C	检验LED亮度 Check LED brightness	目视 Visual	100%	全检Full inspection	PQC检验报表 pectionrecord	返工/报废 Rework / Scrap			
		工作模式Working mode	3	半成品Semi finished product	工作模式测试 Working mode test	D	符合测试作业指导书要求 Meet the requirements of test operation instruction	目视 Visual	100%	全检Full inspection	PQC检验报表 pectionrecord	返工/报废 Rework / Scrap			
		外观 Appearance	4	半成品Semi finished product	目视 Visual	C	无脏污、漏螺丝等外观不良 No dirt, or missing screws or other appearance defects	目视 Visual	100%	全检Full inspection	PQC检验报表 pectionrecord	返工/报废 Rework / Scrap			
		声音Noise	5	半成品Semi finished product	噪音测试 Noise test	D	无噪音、异响 No noise or abnormal	听觉 仪器检测hearing,inst rument inspection	100%	全检Full inspection	PQC检验报表 pectionrecord	返工/报废 Rework / Scrap			
		自动打螺丝设备/ 产品固定治具Automatic equipment Fixture	1	705胶水Glue	打胶 Apply glue	D	①设备气压air pressure0.15-0.2 Mpa 速度speed%20-25 ②设备气压air pressure0.18-0.25 Mpa 速度speed%26-30 ③设备气压air pressure0.22-0.35 Mpa 速度speed%31-35	目视 Visual	5 Pcs	每2小时 Every 2H	首检、巡检记录 表 first piece inspection record + inline inspection record	返工/报废 Rework / Scrap			

Control plan table showing semi-finished product inspection steps: key test, LED check, working mode test, appearance, and noise test, with 100% inspection and record requirements.

Calibration requirements for gauges and instruments (multimeter, comprehensive tester, calipers) are not detailed in the source material and should be defined separately in your gauge management procedure.

During packing, additional checks are performed: inspect the appearance of the finished product for cleanliness, confirm the blister box and batteries are free from damage and foreign matter, clean the product surface with an air gun, and inspect the color box for damage, dirt, or dust before sealing.

Outgoing inspection goes beyond the 100% in-line checks, applying random sampling for a deeper review of appearance, key function, LED brightness, working mode, noise, waterproofing, drop test, packaging method, identification, and weight.

The outgoing inspection checklist specifies exact criteria for each attribute, such as "no dirt or other appearance defects," "check push-button hand feel," "LED brightness," "no noise or abnormal noise, $\leq 58\text{dB}$," "waterproof test for 30 minutes," and "drop test from 1m," along with the applicable sampling quantity and frequency.

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				产品 Product	过程 Process		产品/过程规范/公差 Production / Process Specification / Tolerance	评价/测量技术 Evaluation / Measurement Technique	样本Sampling		数量 Quantity	频率 Frequency			
50	成品检测 Finished product inspection	Fixture		螺钉ScrewK81.5*2.5	battery cover		3.0kgf.cm,make sure the screws is tighten. No sliding wire,or lock not in place,or lock deviation, etc	Inspection		Every 2H			Record + inline inspection record	Scrap	
		手工 manually	4	产品/底盖/防水圈 Product /cover / waterproof ring	合能盖、外观检查 Closing cover, Appearance check	C	检查按摩刷与硅胶套之间不可有间隙 No gap between the massage brush and the silicone sleeve	目视 Visual	5 Pcs	每2小时 Every 2H			首检、巡检记录表 first piece inspection record + inline inspection record	返工/报废 Rework / Scrap	
		按键 Key	1	成品 Finished product	按键测试 Key test	D	检查按键手感合格 Check push-button is qualified	目视 Visual	100%	全检Full inspection			PQC检验报表 Inspection record	返工/报废 Rework / Scrap	
		灯光 LED	2	成品 Finished product	目视 Visual	C	检验LED亮度 Check LED brightness	目视 Visual	100%	全检Full inspection			PQC检验报表 Inspection record	返工/报废 Rework / Scrap	
		工作模式Working mode	3	成品 Finished product	工作模式测试 Working mode test	D	符合测试作业指导书要求 Meet the requirements of test operation instruction	目视 Visual	100%	全检Full inspection			PQC检验报表 Inspection record	返工/报废 Rework / Scrap	
		外观 Appearance	4	成品 Finished product	目视 Visual	C	无脏污等外观不良 No dirt or other appearance defects	目视 Visual	100%	全检Full inspection			PQC检验报表 Inspection record	返工/报废 Rework / Scrap	
		声音Voice	5	成品 Finished product	噪音测试 Noise test	D	无噪音、异响 No noise or abnormal	目视 Visual	100%	全检Full inspection			PQC检验报表 Inspection record	返工/报废 Rework / Scrap	
		防水测试设备 Waterproof test equipment	6	成品 Finished product	防水测试Waterproof test	D	产品放入1m水深30分钟,拆机无进水 The product is put into 1 m water depth for 30 minutes, and no water should be found when disassembled	目视 Visual	2 pcs	每班 Per shift			防水测试记录 Waterproof test record	返工/报废 Rework / Scrap	
		气枪 Air gun	1	成品 Finished product	拆电池、吹尘 Remove battery/Blow dust	C	检查是否漏拆电池,不能有脏污。 No omission to remove the battery and no dirt.	目视 Visual	5 Pcs	每2小时 Every 2H			首检、巡检记录表 first piece inspection record + inline inspection record	返工/报废 Rework / Scrap	

Control plan table highlighting finished product inspection: key test, LED, working mode, appearance, noise, waterproof test, and air gun cleaning, with 100% inspection and reaction plan for defects.

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				产品 Product	过程 Process		产品/过程规范/公差 Production / Process Specification / Tolerance	评价/测量技术 Evaluation / Measurement Technique	样本Sampling				
									数量Quantity	频率 Frequency			
50	成品检测 Finished product inspection	Fixture		螺钉ScrewK81.5*2.5	battery cover		3.0kgf.cm,make sure the screws is tighten. No sliding wire,or lock not in place,or lock deviation,etc	Inspection		Every 2H	记录+inline Inspection record	Scrap	
		手工 manually	4	产品/底盖/防水圈 Product /cover / waterproof ring	合能盖、外观 检查 Closing cover, Appearance check	C	检查按摩刷与硅胶套之间不可有间隙 No gap between the massage brush and the silicone sleeve	目视 Visual	5 Pcs	每2小时 Every 2H	首检、巡检记录 first piece Inspection record + inline Inspection record	返工/报废 Rework / Scrap	
		按键 Key	1	成品 Finished product	按键测试 Key test	D	检查按键手感合格 Check push-button is qualified	目视 Visual	100%	全检Full Inspection	PQC检验报表 Inspection record	返工/报废 Rework / Scrap	
		灯光 LED	2	成品 Finished product	目视 Visual	C	检验LED亮度 Check LED brightness	目视 Visual	100%	全检Full Inspection	PQC检验报表 Inspection record	返工/报废 Rework / Scrap	
		工作模式Working mode	3	成品 Finished product	工作模式测试 Working mode test	D	符合测试作业指导书要求 Meet the requirements of test operation instruction	目视 Visual	100%	全检Full Inspection	PQC检验报表 Inspection record	返工/报废 Rework / Scrap	
		外观 Appearance	4	成品 Finished product	目视 Visual	C	无脏污等外观不良 No dirt or other appearance defects	目视 Visual	100%	全检Full Inspection	PQC检验报表 Inspection record	返工/报废 Rework / Scrap	
		声音Voice	5	成品 Finished product	噪音测试 Noise test	D	无噪音、异响 No noise or abnormal	听觉 仪器检测Hearing,Ins trument inspection	100%	全检Full Inspection	PQC检验报表 Inspection record	返工/报废 Rework / Scrap	
		防水测试设备 Waterproof test equipment	6	成品 Finished product	防水测试Wat erproof test	D	产品放入1m水深30分钟,拆机无进水The product is put into 1 m water depth for 30 minutes, and no water should be found when disassembled	目视 Visual	2 pcs	每班Per shift	防水测试记录 Waterproof test record	返工/报废 Rework / Scrap	
		气枪 Air gun	1	成品 Finished product	拆电池、吹尘 Remove battery/Blow dust	C	检查是否漏拆电池,不能有脏污。 No omission to remove the battery and no dirt.	目视 Visual	5 Pcs	每2小时 Every 2H	首检、巡检记录 first piece Inspection record + inline Inspection record	返工/报废 Rework / Scrap	

Control plan table detailing packing steps: appearance inspection, blister box placement, cleaning, folding color box, and sealing, with inspection methods and reaction plans.

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			编号 No.	产品 Product		过程 Process	产品/过程规范/公差Production / Process Specification / Tolerance	评价/测量技术Eva luation / Measure ment Technique	样本Sampling				
									数量Quantity			频率 Frequency	
70	出货检验 Outgoing inspection	外观 Appearance	1	成品 Finished product	目视 Visual	C	无脏污等外观不良 Should be no dirt and other appearance defects	目视 Visual	GIL AQL0.65/1.0	每批Per lot	OQC检验报表 Inspection record	返工/报废 Rework / Scrap	
		按键 Key	2	成品 Finished product	按键测试 Key test	D	检查按键手感合格 Check push-button handfeel, Should be qualified	目视 Visual	GIL AQL0.65/1.0	每批Per lot	OQC检验报表 Inspection record	返工/报废 Rework / Scrap	
		灯光 LED	3	成品 Finished product	目视 Visual	C	检验LED亮度 Check LED brightness	目视 Visual	GIL AQL0.65/1.0	每批Per lot	返工/报废 Rework / Scrap		
		工作模式Working mode	4	成品 Finished product	工作模式测试 Working mode test	D	应符合测试作业指导书要求 Should Meet the requirements of test operation instruction	目视 Visual	GIL AQL0.65/1.0	每批Per lot	OQC检验报表 Inspection record	返工/报废 Rework / Scrap	
		声音Voice	5	成品 Finished product	噪音测试 Noise test	D	无噪音、异响,≤58db Should be No noise or abnormal,≤58db	听觉 仪器检测Hearing ins trument inspection	GIL AQL0.65/1.0	每批Per lot	OQC检验报表 Inspection record	返工/报废 Rework / Scrap	
		防水测试设备 Waterproof test equipment	6	成品 Finished product	防水测试Wat erproof test	D	产品放入1m水深30分钟,拆机无进水 put into 1 m water depth for 30 minutes, and no water Should be found after disassembled	目视 Visual	2 pcs	每批Per lot	OQC检验报表 Inspection record	返工/报废 Rework / Scrap	
		手工 manually	7	纸箱/产品 Box/Product	跌落测试 Drop Test	D	纸箱从1m高处跌落6个面 产品无破损,功能正常 The box fall from a height of 1 m(6 surfaces).The products Should not be damaged, and the function is normal	目视、仪器检测 Visual instrument inspection	2 pcs	每批Per lot	OQC检验报表 Inspection record	返工/报废 Rework / Scrap	
		手工 manually	8	包装方式Packaging method	目视 Visual	C	符合包装作业指导书要求 Should meet the requirements of the packaging operation instruction	目视 Visual	GIL AQL0.65/1.0	每批Per lot	OQC检验报表 Inspection record	返工/报废 Rework / Scrap	
		手工 manually	9	箱唛 Identification	目视 Visual	C	符合包装作业指导书要求 Should meet the requirements of the packaging operation instruction	目视 Visual	GIL AQL0.65/1.0	每批Per lot	OQC检验报表 Inspection record	返工/报废 Rework / Scrap	
		电子称Electronic	10	称重	目视 Visual	C	应符合包装要求 Should meet the requirements of the packaging operation instruction	目视 Visual	1 box	每批Per lot	OQC检验报表 Inspection record	返工/报废 Rework / Scrap	

Control plan table for outgoing inspection listing appearance, key test, LED, working mode, noise, waterproof test, drop test, packaging, identification, and weight, with random sampling and OQC record.

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				产品 Product	过程 Process		产品/过程规范/公差 Production / Process Specification / Tolerance	评价/测量技术 Evaluation / Measurement Technique	样本Sampling		数量Quantity	频率 Frequency			
70	出货检验 Outgoing Inspection	外观 Appearance	1	成品 Finished product	目视 Visual	C	无脏污等外观不良 Should be no dirt and other appearance defects	目视 Visual	GI, AQL0.65/1.0	每批Per lot	OQC检验报告 Inspection record	返工/报废 Rework / Scrap			
		按键 Key	2	成品 Finished product	按键测试 Key test	D	检查按键手感合格 Check push-button handfeel, Should be qualified	目视 Visual	GI, AQL0.65/1.0	每批Per lot	OQC检验报告 Inspection record	返工/报废 Rework / Scrap			
		灯光 LED	3	成品 Finished product	目视 Visual	C	检验LED亮度 Check LED brightness	目视 Visual	GI, AQL0.65/1.0	每批Per lot	OQC检验报告 Inspection record	返工/报废 Rework / Scrap			
		工作模式Working mode	4	成品 Finished product	工作模式测试 Working mode test	D	符合测试作业指导书要求 Should Meet the requirements of test operation instruction	目视 Visual	GI, AQL0.65/1.0	每批Per lot	OQC检验报告 Inspection record	返工/报废 Rework / Scrap			
		声音Voice	5	成品 Finished product	噪音测试 Noise test	D	无噪音、异响, ≤58db Should be No noise or abnormal, ≤58db	听觉 仪器检测Hearing instrument inspection	GI, AQL0.65/1.0	每批Per lot	OQC检验报告 Inspection record	返工/报废 Rework / Scrap			
		防水测试设备 Waterproof test equipment	6	成品 Finished product	防水测试 Waterproof test	D	产品放入1m水深30分钟, 拆机无进水 put into 1 m water depth for 30 minutes, and no water Should be found after disassembled	目视 Visual	2 pcs	每批Per lot	OQC检验报告 Inspection record	返工/报废 Rework / Scrap			
		手工 manually	7	纸箱/产品 Box/Product	跌落测试 Drop Test	D	纸箱从1m高处跌落6个面 产品无破损, 功能正常 The box fall from a height of 1 m (6 surfaces). The products Should not be damaged, and the function is normal	目视、仪器检测 Visual instrument inspection	2 pcs	每批Per lot	OQC检验报告 Inspection record	返工/报废 Rework / Scrap			
		手工 manually	8	包装方式Packaging method	目视 Visual	C	符合包装作业指导书要求 Should meet the requirements of the packaging operation instruction	目视 Visual	GI, AQL0.65/1.0	每批Per lot	OQC检验报告 Inspection record	返工/报废 Rework / Scrap			
		手工 manually	9	箱唛 Identification	目视 Visual	C	符合包装作业指导书要求 Should meet the requirements of the packaging operation instruction	目视 Visual	GI, AQL0.65/1.0	每批Per lot	OQC检验报告 Inspection record	返工/报废 Rework / Scrap			
		电子称Electronic	10	称重	目视 Visual	C	符合包装要求 Should meet the requirements of the packaging operation instruction	目视 Visual	1 box	每批Per lot	OQC检验报告 Inspection record	返工/报废 Rework / Scrap			

Control plan table showing the detailed outgoing inspection checklist, including criteria, sampling, and documentation requirements.

Reaction plan

The reaction plan defines what happens when a check fails at any stage.

- Immediate containment: For incoming goods, sort out the non-conforming item and return it to the supplier. For in-process defects (soldering, EVA sticking, shell/nut mounting, PCBA locking, glue application, battery cover assembly), rework or scrap the item.
- Escalation: Inspections are performed by the production line leader or by an external inspector from the quality department; either role can raise a non-conformity for action.
- Disposition: Place defective finished products in a designated red box (or similar container) so they are not mixed with conforming products, pending rework or scrap decision.
- Restart criteria: Perform a first piece inspection immediately after starting assembly. If problems are found, stop and correct them before continuing mass production. Routine in-process inspection of 5 pieces every 2 hours then continues for all critical assembly steps.

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				Revision level:		Release Date:		Dec. 17, 2019		Status		First version	
零件/过程 编号 Part / Process Number	过程名称/操 作描述Process Name / Work Description	设备、装置、夹 具、刀具Machin e / Device / Jig / Tool	编号 No.	特性Characteristics		特殊特性 分类Special Character istics	方法Method						
				产品 Product	过程 Process		产品/过程规范/公差Production / Process Specification / Tolerance	评价/测量技术Eval uation / Measurement Technique	样本Sampling		控制方法 Control Method	反应计划 Reaction Plan	
									数量Quantity	频率 Frequency			
	烙铁Soldering Iron		1	PCBA 板\电子导线	PCBA 焊线 PCBA welding wire	C	作业前戴好有线静电环,每个焊点时间2-3S,烙铁温度: 350℃±30℃,检查锡点光滑、饱满、无连锡、线焊错不良。Wear wired static rings before operation, Time of each welding spot is 2-3s, Temperature of soldering iron: 350℃±30℃. The tin spot is smooth, full, free of tin connection and wire welding error	目视、烙铁温度检测 Visual, soldering iron temperature inspection	5 Pcs	每2小时 Every 2H	首检、巡检记录 表 first piece inspection record + inline inspection record	返工/报废 Rework / Scrap	
	镊子 Tweezers		2	PCBA 板\EVA	主板贴EVA Main board EVA sticking	C	作业前戴好有线静电环,EVA贴于PCBA按键不能歪、不能挡就灯。Wear wired static rings before operation, EVA cannot be skewed. No occlusion LED	目视 Visual	5 Pcs	每2小时 Every 2H	首检、巡检记录 表 first piece inspection record + inline inspection record	返工/报废 Rework / Scrap	
	手啤机/外壳底模 Hand Die Cutting machine / bottom mold of shell		3	外壳/螺母 Shell / Nut	外壳装螺母 Shell mounted nut	C	螺母压到底,啤机不能压伤外壳The nut is pressed to the bottom. No damage to the shell	目视 Visual	5 Pcs	每2小时 Every 2H	首检、巡检记录 表 first piece inspection record + inline inspection record	返工/报废 Rework / Scrap	
	电批/治具Electri c screwdriver / Fixture		4	外壳Shell/PCBA 螺丝Screw PB2*3	外壳锁PCBA 板 Lock PCBA board	A	电批扭力: 2.0kgf.cm~2.5kgf.cm,检查螺丝无漏打或未打到位,用手确认按键手感良好,无按键卡死或按键手感不良Torque of electric screwdriver: 2.0kgf.cm ~ 2.5kgf.cm, The screws are not missed or not in place, Confirm the handfeel of push-button is good, and there is no stuck	目视、仪器检测 Visual instrument Inspection	5 Pcs	每2小时 Every 2H	首检、巡检记录 表 first piece inspection record + inline inspection record	返工/报废 Rework / Scrap	
							作业前戴好有线静电环 检查弹簧是否装到PCBA板,和塑胶台座上We				首检、巡检记录 表 first piece	返工/报废	

Control plan table showing inspection frequency (5 pieces every 2 hours), responsible parties, and documentation requirements for pre-assembly steps.

Special characteristics marked "A" or "D" are treated as critical to product quality – for example, the battery cover screw torque – and any deviation follows the same rework-or-scrap reaction path documented in the first piece inspection record and inline inspection record.

				PROCESS CONTROL PLAN Product [Confidential]											
				Revision (revision)		A1		Release Date:		Dec. 17, 2019		Status		First version	
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				产品 Product	过程 Process		产品/过程规范/公差 Specification / Tolerance	评价/测量技术 Eval uation / Measure ment Technique	样本Sampling		频率 Frequency				
									数量Quantity	数量Quantity					
50	成品检测 Finished product inspection	Fixture		螺钉ScrewK81.5*2.5	battery cover		3.0kgf.cm,make sure the screws is tighten, No sliding wire,or lock not in place,or lock deviation, etc	Inspection		Every 2H		记录+inline inspection record	Scrap		
		手工 manually	4	产品/底盖/防水圈 Product /cover / waterproof ring	合尾盖、外观检查 Closing cover, Appearance check	C	检查按摩刷与硅胶套之间不可有间隙 No gap between the massage brush and the silicone sleeve	目视 Visual	5 Pcs	每2小时 Every 2H		首检、巡检记录表 first piece inspection record + inline inspection record	返工/报废 Rework / Scrap		
		按键 Key	1	成品 Finished product	按键测试 Key test	D	检查按键手感合格 Check push-button is qualified	目视 Visual	100%	全检Full inspection		PQC检验报表 pection record	返工/报废 Rework / Scrap		
		灯光 LED	2	成品 Finished product	目视 Visual	C	检验LED亮度 Check LED brightness	目视 Visual	100%	全检Full inspection		PQC检验报表 pection record	返工/报废 Rework / Scrap		
		工作模式Working mode	3	成品 Finished product	工作模式测试 Working mode test	D	符合测试作业指导书要求 Meet the requirements of test operation instruction	目视 Visual	100%	全检Full inspection		PQC检验报表 pection record	返工/报废 Rework / Scrap		
		外观 Appearance	4	成品 Finished product	目视 Visual	C	无脏污等外观不良 No dirt or other appearance defects	目视 Visual	100%	全检Full inspection		PQC检验报表 pection record	返工/报废 Rework / Scrap		
		声音Voice	5	成品 Finished product	噪音测试 Noise test	D	无噪音、异响 No noise or abnormal	听觉 仪器检测Hearing instrument inspection	100%	全检Full inspection		PQC检验报表 pection record	返工/报废 Rework / Scrap		
		防水测试设备 Waterproof test equipment	6	成品 Finished product	防水测试Waterproof test	D	产品放入1m水深30分钟,拆机无进水 The product is put into 1 m water depth for 30 minutes, and no water should be found when disassembled	目视 Visual	2 pcs	每班 Per shift		防水测试记录 Waterproof test record	返工/报废 Rework / Scrap		
		气枪 Air gun	1	成品 Finished product	拆电池、吹尘 Remove battery/Blow dust	C	检查是否漏拆电池,不能有脏污。 No omission to remove the battery and no dirt.	目视 Visual	5 Pcs	每2小时 Every 2H		首检、巡检记录表 first piece inspection record + inline inspection record	返工/报废 Rework / Scrap		

Control plan table showing continued packing steps and reaction plans for non-conforming products, emphasizing designated containers for defective items.

Revision history

Document control ensures only the latest, approved version of the control plan is used in production and inspection, and it provides traceability for changes.

Revision	Reason for change	Approver	Effective date
A1	Added process for outgoing inspection and equipment parameters for glue equipment, etc.	AlexChen	Dec. 17, 2019

Keep documents stored securely and organized to prevent loss or unauthorized changes, and review them regularly as processes or requirements change. Always refer to the current version of the control plan and its associated checklists during operations.

What's next

Once your control plan is drafted, link each process row to its corresponding PFMEA entry, confirm gauge calibration schedules with your quality team, and train operators and inspectors on the sampling frequency and reaction plan for each step before releasing the plan for production use.

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								数量Quantity	频率 frequency				
		手工.manually	8	包装方式Packaging method	目视 Visual	C	符合包装作业指导书要求 Should meet the requirements of the packaging operation instruction	目视 Visual	GIL AQL0.65/1.0	每批Per lot	OQC检验报表in specification record	返工/报废 Rework / Scrap	
		手工.manually	9	箱唛 Identification	目视 Visual	C	符合包装作业指导书要求 Should meet the requirements of the packaging operation instruction	目视 Visual	GIL AQL0.65/1.0	每批Per lot	OQC检验报表in specification record	返工/报废 Rework / Scrap	
		电子秤Electronic balance	10	称重 Weigh	目视 Visual	C	符合包装要求 Should meet the requirements of the packaging	目视 Visual	1 box	每批Per lot	OQC检验报表in specification record	返工/报废 Rework / Scrap	
Special Characteristics Definition: 特殊特性定义: An abbreviation of the classification that has been assigned to the process characteristics. If any. This field is used to identify characteristics that require special manufacturing control (e.g., Critical, Significant, Key Leading, etc.). 已分配给过程特性的分类的缩写 (如果有的话)。此字段用于识别需要特殊制造控制的特性 (如关键、重要、关键领导等)。 For example 例如 A = Critical to Quality and therefore needs to have very specific actions taken A=对质量至关重要, 因此需要采取非常具体的措施 B = Functional dimensions and therefore tolerances need to be monitored B=功能尺寸, 因此需要监控公差 C = Specific attributes need monitoring with SPC C=需要使用SPC监控的特定属性 D = Function inspection required D=需要进行功能检查													
DOCUMENT CONTROL DATA 文件控制数据													
Revision		A1		Description of change									
Author		AlexChen		This change									
Date Released		Dec. 17, 2019		Included 增加了出货检验及组装打胶的设备参数等Added process outgoing inspection and equipment parameters for glue equipment ect.									

Control plan table showing special characteristics definitions and document control data, summarizing the importance of document control.